

Work Order ID 78446

January-10-12 9:27:02 AM

SHIP 25 JAN
Blue
78446

Page 1

Item ID: D206-642-341

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 10/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.D.

Date: 12/01/10 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2650

F

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 78446***78446***

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/RAluminum Rod

4-Grind weld flush to cap on top surface only.

5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

2 } SAD 12-01-16

3 } BE12-01-16

5 } SAD 12-01-16

9 } SAD 12-01-16

| W/O: | | WORK ORDER CHANGES | | | | | |
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Required Date: 25/01/2012 Req'd Qty: 1.00

1

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

125

QC3- Inspect Part Finish

0.00

125

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NS2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs.
cure time before cutting

Start Date: 12-01-17 Time: 2h30

Finish Date: 12-01-19 Time: 8:00

A/RSikaflex-291 71119508

Sikaflex expiry date: 2012-08-13

SAD 12-01-17

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

1 8 BE 12-01-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

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January-10-12 9:27:02 AM

Item ID: D206-642-341

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 10/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00

150

Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/RAluminum Rod M119785

BE 12-01-19

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

B

12/01/19

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

DP

12-1-23

4- Install nut plate as per dwg

B

12/01/19

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

8/12/12

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78446

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January-10-12 9:27:02 AM

Item ID: D206-642-341

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 10/01/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

180 QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo

Quality Control

190 Pressure Wash per QSI005 4.3 0.00

190

HandFinish

Memo

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

200 ***200*** spray paint

Powdercoat

Powder Coating

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum 0.00

Memo

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

Prime M 117319
Delfleet Blue M 118395
clear Delfleet M 118093

1X PM 12/01/23

12.01.23 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78446***78446***

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Item ID: D206-642-341

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 10/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00

210

QC

QC14

Memo

0.00

Quality Control

① B 12.01.24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78446

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78446

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Item ID: D206-642-341 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 10/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

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|-----|---------------|------|--|--|--|--|--|--|--|
| 220 | HandFinishing | 0.00 | | | | | | | |
|-----|---------------|------|--|--|--|--|--|--|--|

220
 HandFinish Memo 0.00

- Hand Finishing
- 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.
 A/RSikaflex-291 1119443
 Sikaflex expiry date: 12/01
 - 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive
 - 3-Install MS27039-4-06 Screw
 - 4-Inspect for foreign object per QSI 024
 - 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive
 A/RSikaflex-291 1119443
 Sikaflex expiry date: 12/01
 - 6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4
 Batch: 1112012

11/12/01/20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78446***78446***

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Item ID: D206-642-341 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube
Start Date: 10/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 25/01/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 230 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *230* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 240 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *240* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 250 | Packaging | 0.00 | | | | | | | |
| *250* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D206-642-341 | | | | | | | | |
| | Location: | | | | | | | | |
| | PPP Rev: | | | | | | | | |

Handwritten notes and signatures:

- Under 230: ***230***, QC, Quality Control, Accept Qty: 12, Reject Qty: 01, Insp. Stamp: 25 (1)
- Under 240: ***240***, QC, Quality Control, Accept Qty: 12, Reject Qty: 01, Insp. Stamp: 25 (1)
- Under 250: ***250***, Packaging, Memo, Identify and pack for shipping as per PPP D206-642-341, Location: *1178400*, Insp. Stamp: *1/10/12*

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Work Order ID 78446***78446***

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January-10-12 9:27:02 AM

Item ID: D206-642-341

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 10/01/2012 Start Qty: 1.00 ***1***

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Required Date: 25/01/2012 Req'd Qty: 1.00 ***1***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept Reject Reject Insp.
Qty Qty Number Stamp

260

QC21- Final Inspection - Work Order Release

0.00

260

QC

Memo

0.00

Quality Control

12/1/25

ME
12-1-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 78446

78446

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

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|------------|---------------|-----------|----|--|--|--|------|--------|--|---|--|--|--|
| AN960JD416 | NAS1149D0463J | Purchased | No | | | | Each | 0.0000 | | 1 | | | |
|------------|---------------|-----------|----|--|--|--|------|--------|--|---|--|--|--|

AN960JD416 ✕

Washer

| | | | | | | | | | | | | | |
|-------------|--|-----------|----|--|--|--|------|----------|--|---|--|--|--|
| CCR264SS3-3 | | Purchased | No | | | | Each | 947.0000 | | 2 | | | |
|-------------|--|-----------|----|--|--|--|------|----------|--|---|--|--|--|

CCR264SS3-3

Cherry Rivet

Location

Loc Qty

Loc Code

ST331

947

113973

2

117849

139

119017

806

| | | | | | | | | | | | | | |
|-------------|--|-----------|----|--|--|--|------|-----------|--|---|--|--|--|
| CR3212-4-03 | | Purchased | No | | | | Each | 1,716.000 | | 2 | | | |
|-------------|--|-----------|----|--|--|--|------|-----------|--|---|--|--|--|

CR3212-4-03

Cherry Rivet

Location

Loc Qty

Loc Code

FP002

724

114859

724

ST331

992

110139

2

119017

990

**

N1118384 (x1) M 12/01/25

**

2
2 12/01/19

**

2
2 12/01/19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

January-10-12 9:27:06 AM

Page 2

Work Order ID: 78446

78446

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2620

Manufactured No

Each

25.0000

1

D2620

Skidtube, 206 Skidtube

**

SAD 12-01-16

Location

Loc Qty

Loc Code

LG

25

71616

1

71617

6

75587

2

76815

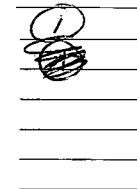
3

76817

10

76819

3



D2647

Manufactured No

Each

161.0000

1

D2647

Cap

**

BE12-01-16

Location

Loc Qty

Loc Code

LG002

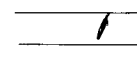
161

73826

52

75482

109



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

January-10-12 9:27:07 AM

Page 3

Work Order ID: 78446

78446

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured

No

Each

637.0000

19

D2649

Cross Bolt Spacer

**

DE 12-01-19

Location

Loc Qty

Loc Code

LG

400

77574

400

19

LG001

237

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

76793

118

D2654-5

Manufactured

No

Each

0.0000

1

D2654-5

Web

B78832

**

SAD

12-01-17

D2680-041

Manufactured

No

Each

140.0000

1

D2680-041

Nut Plate

**

1

12/01/19

Location

Loc Qty

Loc Code

ST013

44

75479

44

ST019

96

76790

96

January-10-12 9:27:07 AM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

January-10-12 9:27:07 AM

Page 4

Work Order ID: 78446

78446

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

Each

766.0000

56

MS27039C1-08

SCREW

**

12/01/25

Location

Loc Qty

Loc Code

FP002

1

116022

1

ST293

765

116373

3

118077

150

118159

500

119309

112

X56

ALS4-1032-130

Purchased

No

220

Each

1,684.000

54

54

AI S4-1032-130

Insert

**

12/01/25

Location

Loc Qty

Loc Code

ST280

1589

119084

1589

ST281

95

119632

95

X54

AN960C10L

NAS1149C0332

Purchased

No

220

Each

0.0000

54

54

*AN960C10I * ✕

washer

**

1119736 (x54) 12/01/25

AN960JD10L

NAS1149D0332J

Purchased

No

220

Each

0.0000

2

2

*AN960.ID10I * ✕

Washer

**

1119042 (x2) 12/01/27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 78446

78446

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

220 Each

122.0000 1 1

D2646

Aft Cap

**

HL 12/01/12

Location

Loc Qty

Loc Code

FP002

122

62678

5

68280

5

70945

1

71038

4

71070

2

73294

1

73825

104

X1

D2651-1

Manufactured No

220 Each

177.0000 14 14

D2651-1

Plug

**

1370942 (x14) HL 12/01/12

Location

Loc Qty

Loc Code

FP001

177

57869

1

66445

10

69018

2

70839

2

71037

31

73827

131

D2651-3

Manufactured No

220 Each

2,667.000 14 14

D2651-3

O-Ring

**

HL 12/01/12

Location

Loc Qty

Loc Code

FP001

667

61962

12

73828

655

FP-A

2000

78126

2000

X14

January-10-12 9:27:07 AM

Shop Packet Print

Page 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 78446

78446

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|-------------------|--------------|----|-----|------|---------|----|----------|
| D3535-11 | Manufactured | No | 220 | Each | 18.0000 | 1 | 1 |
| *D3535-11* | | | | | | ** | 12/01/25 |
| Wearshoe | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001 | 18 | |
| 70879 | 5 | |
| 71284 | 13 | |

| | | | | | | | |
|-------------------|--------------|----|-----|------|---------|----|----------|
| D3535-23 | Manufactured | No | 220 | Each | 34.0000 | 1 | 1 |
| *D3535-23* | | | | | | ** | 12/01/25 |
| Wearshoe | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001 | 34 | |
| 73314 | 23 | |
| 74508 | 11 | |

| | | | | | | | |
|-------------------|--------------|----|-----|------|---------|----|----------|
| D3535-35 | Manufactured | No | 220 | Each | 21.0000 | 1 | 1 |
| *D3535-35* | | | | | | ** | 12/01/25 |
| Wearshoe | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP001 | 21 | |
| 67598 | 1 | |
| 70815 | 1 | |
| 73311 | 7 | |
| 74509 | 12 | |

| | | | | | | | |
|-------------------|--------------|----|-----|------|---------|----|----------|
| D3536-11 | Manufactured | No | 220 | Each | 14.0000 | 1 | 1 |
| *D3536-11* | | | | | | ** | 12/01/25 |
| Gasket | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP002 | 14 | |
| 46649 | 1 | |
| 46715 | 4 | |
| 65574 | 1 | |
| 71283 | 8 | |

January-10-12 9:27:07 AM

Shop Packet Print

Page 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

January-10-12 9:27:07 AM

Page 7

Work Order ID: 78446

78446

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|-------------------|--------------|----|-----|------|---------|----|--------------------|
| D3536-23 | Manufactured | No | 220 | Each | 33.0000 | 1 | 1 |
| *D3536-23* | | | | | | ** | <u>11</u> 12/01/25 |
| Gasket | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP002 | 33 | |
| 43406 | 1 | |
| 73312 | 20 | <u>Y1</u> |
| 74510 | 12 | |

| | | | | | | | |
|-------------------|--------------|----|-----|------|---------|----|--------------------|
| D3536-35 | Manufactured | No | 220 | Each | 32.0000 | 1 | 1 |
| *D3536-35* | | | | | | ** | <u>11</u> 12/01/27 |
| Gasket | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP002 | 32 | |
| 73313 | 14 | <u>X1</u> |
| 74511 | 18 | |

| | | | | | | | |
|------------------|--------------|----|-----|------|---------|----|--------------------|
| D3537-1 | Manufactured | No | 220 | Each | 56.0000 | 6 | 6 |
| *D3537-1* | | | | | | ** | <u>11</u> 12/01/25 |
| Wearpad | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP002 | 56 | |
| 69817 | 5 | |
| 77036 | 51 | <u>X6</u> |

| | | | | | | | |
|------------------|--------------|----|-----|------|---------|----|--------------------|
| D3537-3 | Manufactured | No | 220 | Each | 12.0000 | 1 | 1 |
| *D3537-3* | | | | | | ** | <u>11</u> 12/01/25 |
| Wearpad | | | | | | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP002 | 12 | |
| 76986 | 12 | <u>Y1</u> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

January-10-12 9:27:07 AM

Page 8

Work Order ID: 78446

78446

Parent Item: D206-642-341

D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 10/01/2012

Required Date: 25/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

220

Each

296.0000

1

1

MS27039-4-06

Screw

**

24 21 01/27

Location

Loc Qty

Loc Code

ST292

296

119075

296

81

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| QTY -1 | QTY -3 | QTY -5 | QTY -7 | PART NUMBER | DESCRIPTION |
|-----------|-----------|-----------|-----------|---------------|---------------------------------------------------------|
| X | | | | D2650-1 | SKIDTUBE ASSEMBLY |
| | X | | | D2650-3 | SKIDTUBE ASSEMBLY |
| | | X | | D2650-5 | SKIDTUBE ASSEMBLY |
| | | | X | D2650-7 | SKIDTUBE ASSEMBLY |
| 1 | 1 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 1 | | | | D2654-1 | WEB |
| | 1 | | | D2654-3 | WEB |
| | | 1 | | D2654-5 | WEB |
| | | | 1 | D2654-7 | WEB |
| 1 | 1 | 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | 1 | 1 | D2647 | CAP |
| 17 | 18 | 19 | 23 | D2649 | CROSS BOLT SPACER |
| 16 | 18 | 14 | 22 | D2651-1 | PLUG |
| 16 | 18 | 14 | 22 | D2651-3 | O-RING |
| 1 | 1 | 1 | 1 | D2680-041 | NUT PLATE |
| 2 | 2 | | | D3286-1 | DOUBLER |
| 2 | 2 | | | D3286-3 | STUD |
| 42 | 44 | 54 | 60 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) |
| 2 | 2 | 2 | 2 | AN960JD10L | WASHER |
| 2 | 2 | 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | 2 | 2 | MS27039-1-08 | SCREW |
| 1 | 1 | 1 | 1 | MS27039-4-06 | SCREW |
| 1 | 1 | 1 | 1 | AN960JD416 | WASHER |
| 52 | 52 | | | CR3212-4-04 | RIVET |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78446 M.L.J
12/01/16

RELEASED
08-23-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | | |
|------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| F | DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239). | AJS | 08.08.08 |
| E | REMOVE CBORE, CHG DRILL, ADD CHAMFER | CP | 06.03.30 |
| D | REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3 | CP | 04.05.17 |
| C | CHANGE HOLE PATTERN AND FRONT END | DS | 97.10.29 |
| B | AS MANUFACTURED CHANGES | DS | 97.06.26 |
| A | NEW ISSUE | DS | 97.03.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 1 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
| DATE | 08.08.08 | COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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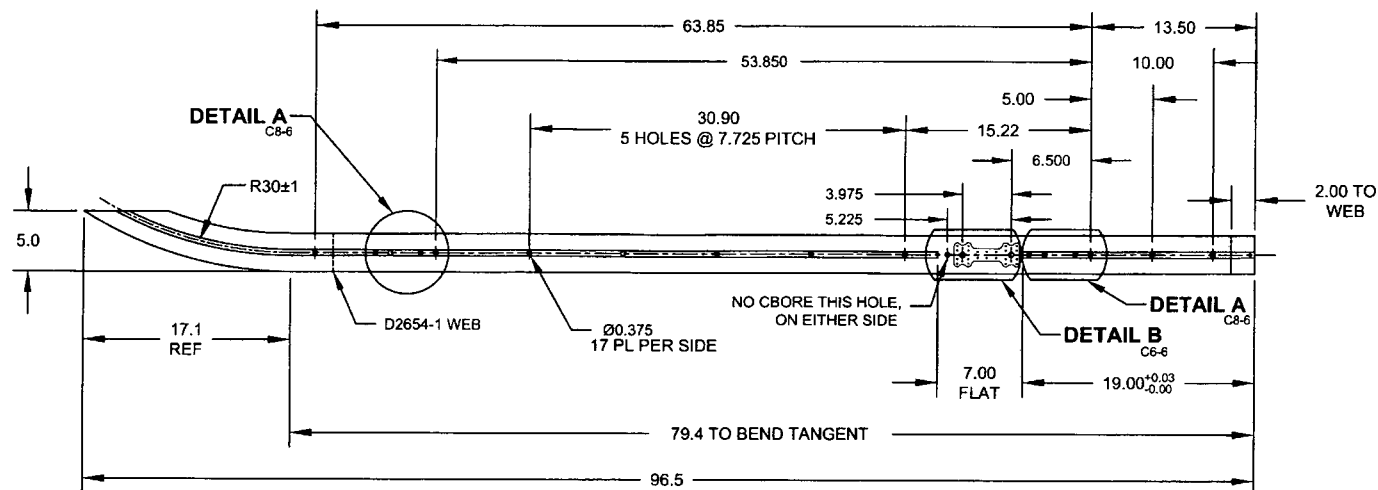
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

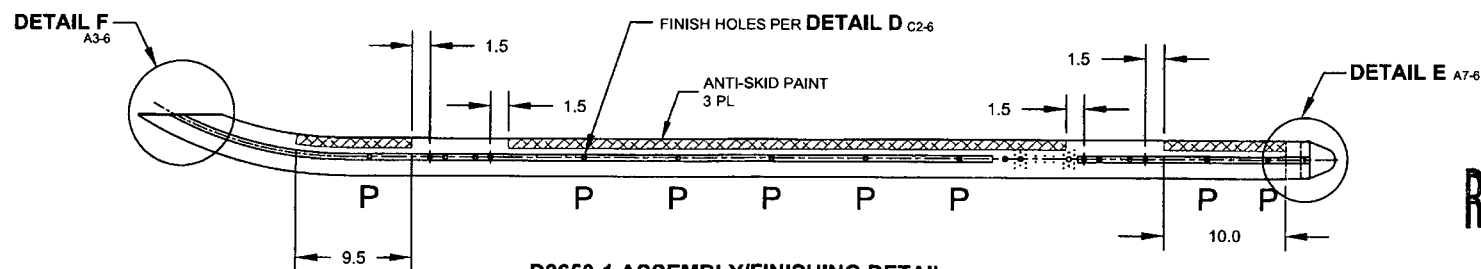
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

78446



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED
680922/117

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|------------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 2 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
| DATE | 08.08.08 | <small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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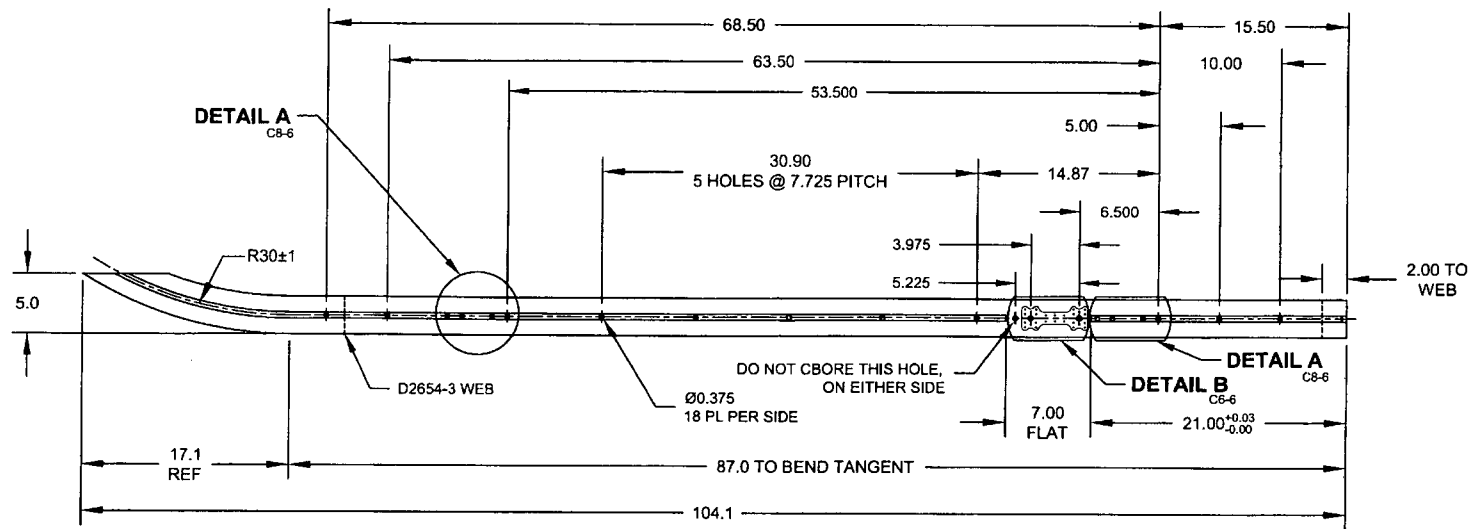
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

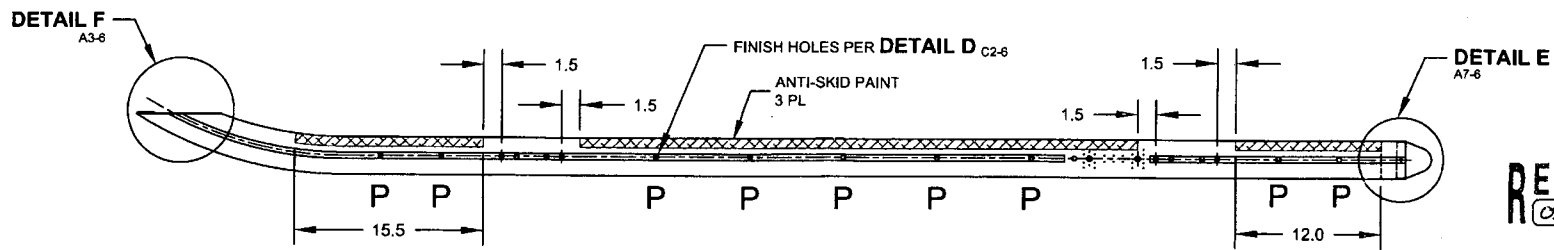
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

78446



D2650-3 BENDING/DRILLING DETAIL



D2650-3 ASSEMBLY/FINISHING DETAIL

RELEASED
08-07-22

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| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 3 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
| DATE | 08.08.08 | <small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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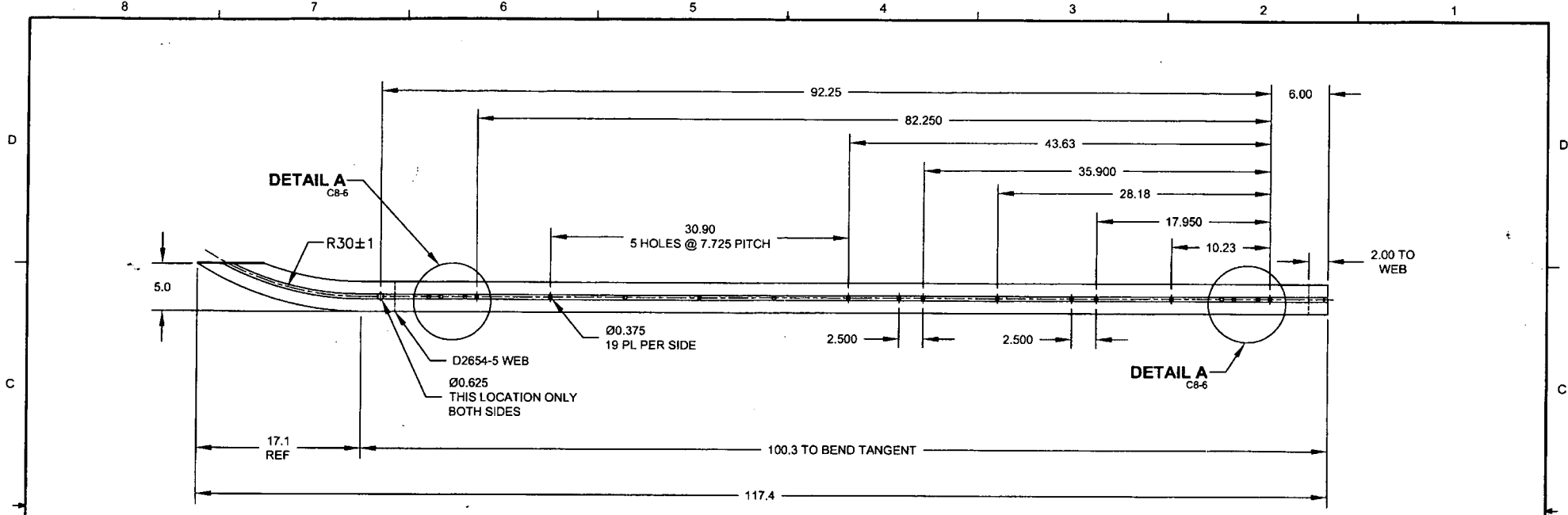
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

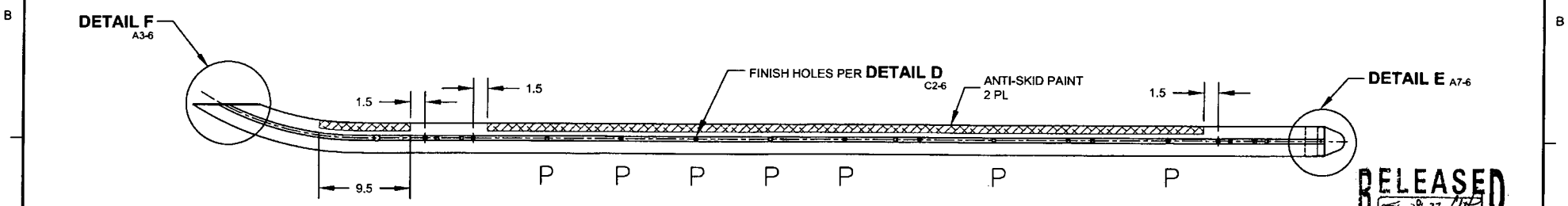
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

78.446



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

RELEASED
08.09.22/117

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| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 4 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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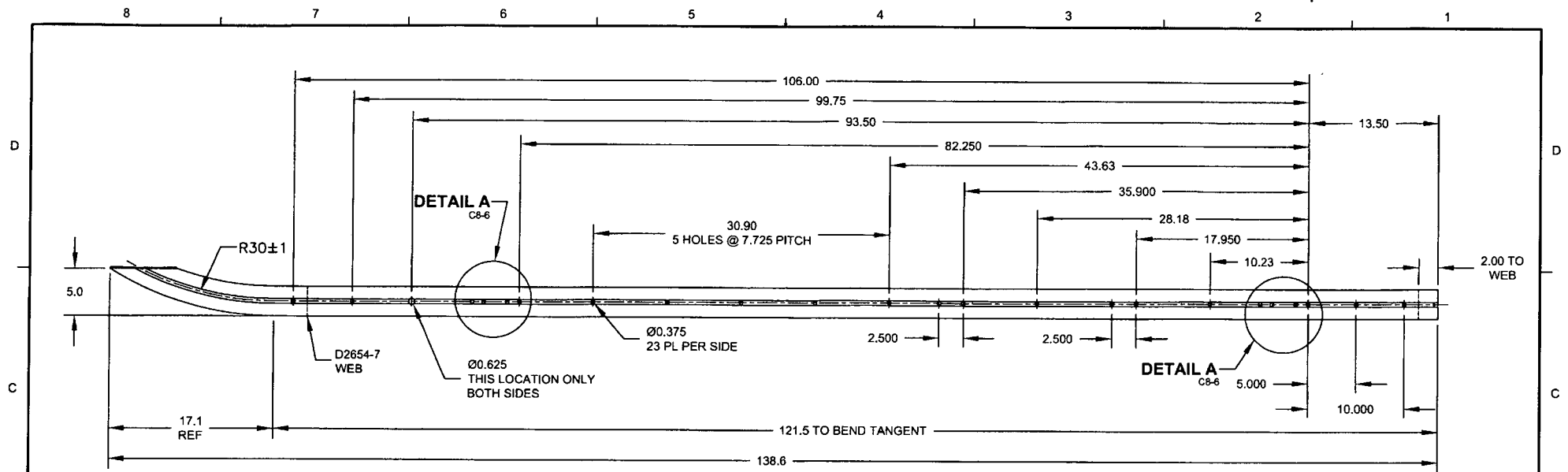
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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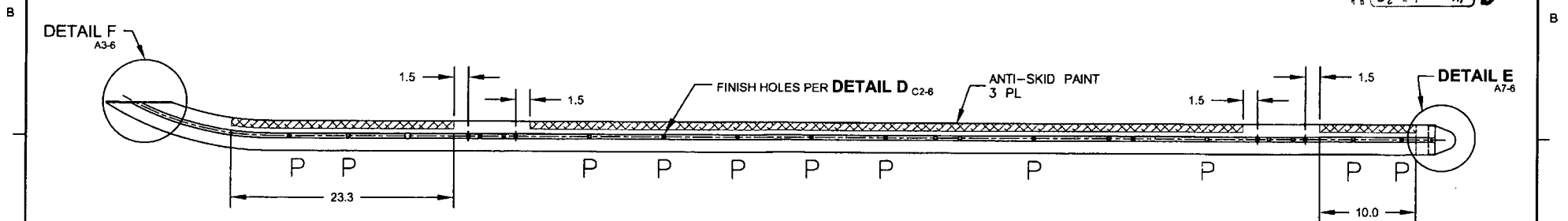
NOTE: Date & initial all entries

78446



D2650-7 BENDING/DRILL DETAIL

RELEASED
02 07-22 1/11



D2650-7 ASSEMBLY/FINISHING DETAIL

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| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | A/S | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 5 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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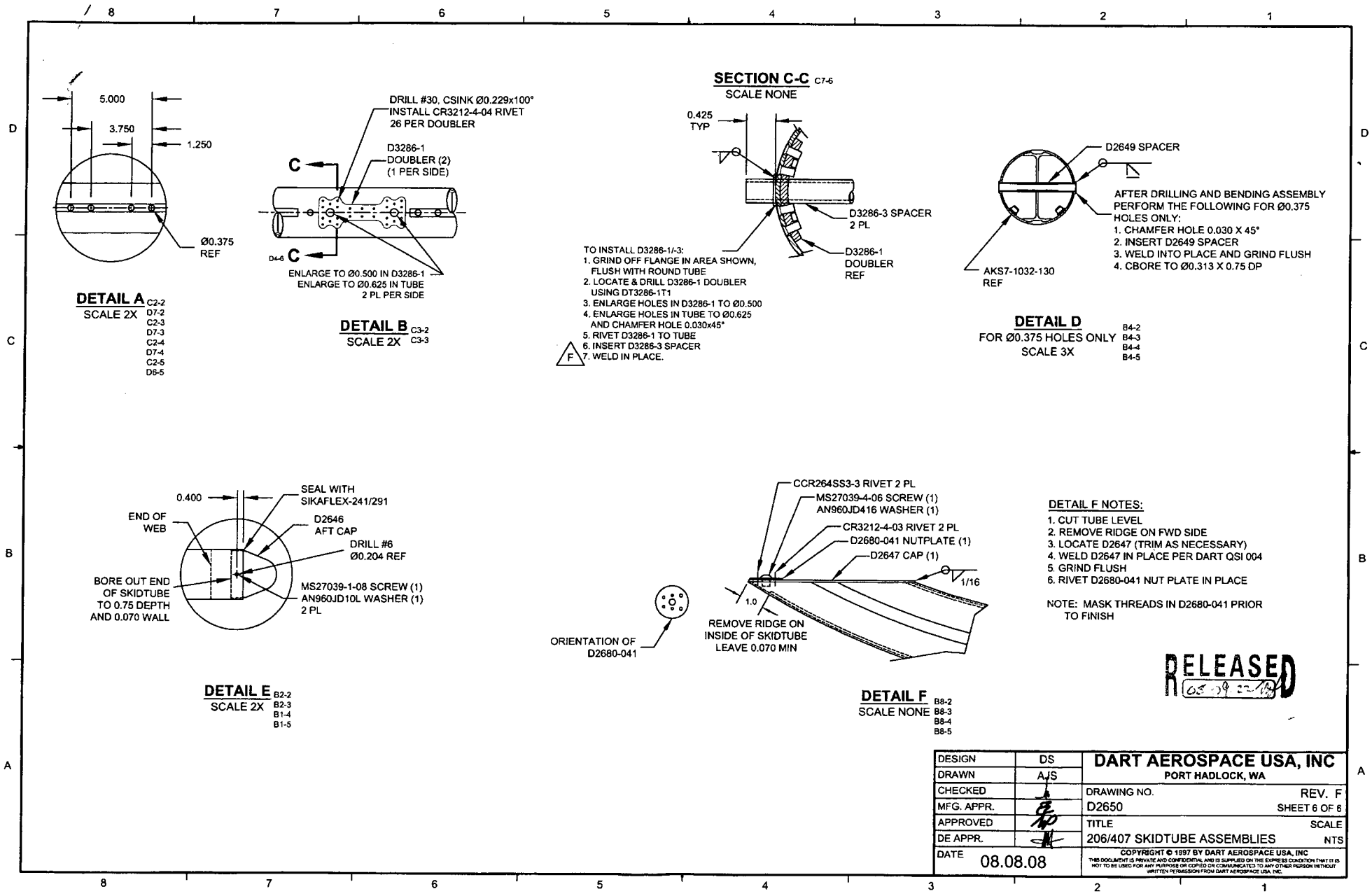
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

78446



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|------------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 6 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 278

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 766119
Part number: 206-642-151
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat. Dunn Date of Test Coupon 11-12-20
Welder Barclay Elliot Date of Test Coupon 11-12-20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld